



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200  
Fax 613 632-5246

D3009-3

Job Sheet 215873



Part No: D3009-3

Job Qty: 60 pcs

Part Name: Cup



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/24/20

Job Tracking No:

Due Date: 12/16/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP A 07.12.18 new issue EC IPP Rev:B 08-01-08 ECN 1089 rev:b as per dwg DD verified by:ec

Ship Via:

## Bill of Materials

## Job Routing

| Op<br>No | Operation    | Qty    | Start Date | Due<br>Date | Standard     |            | Workcenter/Supplier   |           | Sign off                    |
|----------|--------------|--------|------------|-------------|--------------|------------|-----------------------|-----------|-----------------------------|
|          |              |        |            |             | Setup<br>Hrs | Run<br>Hrs | Workcenter / Supplier | Lead Time |                             |
| 100      | Hardinge - 1 | 60 pcs | 12/16/20   | 12/16/20    | 0.50         | 4.00       | Hardinge - 1          |           | <i>[Signature]</i> 20/12/20 |
| 120      | QC 8         | 60 pcs | 12/16/20   | 12/16/20    | 0.00         | 0.00       | QC 8 - 12             |           | <i>[Signature]</i> 20/12/20 |
|          |              |        |            |             |              |            | QC 8 - 14             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 17             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 20             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 25             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 3              |           |                             |
|          |              |        |            |             |              |            | QC 8 - 32             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 33             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 35             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 39             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 4              |           |                             |
|          |              |        |            |             |              |            | QC 8 - 44             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 45             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 49             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 58             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 8              |           |                             |
|          |              |        |            |             |              |            | QC 8 - 9              |           |                             |
|          |              |        |            |             |              |            | QC 8 - 68             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 67             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 1 (A)          |           |                             |
|          |              |        |            |             |              |            | QC 8 - 47             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 40             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 52             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 23             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 57             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 76             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 61             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 66             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 73             |           |                             |
|          |              |        |            |             |              |            | QC 8 - 82             |           |                             |



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Container No: S318491



Part: D3009-3

Job No: 215873

Serial No/Batch: S318491

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 12/06/20

130 Packaging 3-1 - Stock - B4B 60 pcs ✓

12/16/20

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B ✓

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

Packaging 3 - 37 - B4B

DAS

DEC 07 2020 80

WA001-15 9-89

140 QC 21 - SA

60 pcs

12/16/20

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

QC 21 - SA - 9

QC 21 - SA - 77

QC 21 - SA - 28

DAS  
21  
9-89

DEC 07 2020

Part Op 100 - (Hardinge)1-TURN AS PER FOLIO FA130 &amp; DWG D3009

Descriptions: 120 - (QC8- Inspect parts - second check)

130 - Identify as per dwg &amp; Stock Location: WA001-15. \*\*\*\*\*STOCK IN LARGE FAB\*\*\*\*\*

140 - QC21- Final Inspection - Work Order Release)

## Job BOM

| Part / Item | Component Name     | Quantity             | Operation        | Container |
|-------------|--------------------|----------------------|------------------|-----------|
| M304R1.000  | 304 Round Bar 1.00 | 2.8740 ft (.0479 ea) | 100-Hardinge - 1 | S312793   |

## Job Allocations

| Operation        | Component Part | Required | Inventory | Allocated |
|------------------|----------------|----------|-----------|-----------|
| 100-Hardinge - 1 | M304R1.000     | 3        | 23        | 0         |

| Part Specifications |             |                                |                  |       |                  |
|---------------------|-------------|--------------------------------|------------------|-------|------------------|
| Spec No             | Description | Target/Tolerance               | Limits           | Type  | Special Comments |
| 1                   | Cup         | 0.875Inches + 0.000<br>- 0.005 | 0.875<br>0.870   | .873  | Diameter         |
| 2                   | Cup         | 0.750Inches + 0.008<br>- 0.001 | 0.758<br>0.749   | .752  | Diameter         |
| 3                   | Cup         | 0.266Inches + 0.006<br>- 0.001 | 0.272<br>0.265   | .2665 | Diameter         |
| 4                   | Cup         | 0.062Inches ± 0.010            | 0.072<br>0.052   | .06   | Radius           |
| 5                   | Cup         | 0.094Inches ± 0.010            | 0.104<br>0.084   | .0925 |                  |
| 6                   | Cup         | 0.353Inches ± 0.010            | 0.363<br>0.343   | .3545 |                  |
| 7                   | Cup         | 0.063Inches ± 0.010            | 0.073<br>0.053   | .06   |                  |
| 8                   | Cup         | 0.032Inches ± 0.010            | 0.042<br>0.022   | .034  | Radius           |
| 9                   | Cup         | 45.000Degrees ± 0.000          | 45.000<br>45.000 | 45    | Angle            |

Plex 11/24/20 9:56 AM Dart.lajeunesse.marie

Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QSI042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |